DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026855
Date Inspected: 09-Dec-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Job Site

CWI Name: Salvador Merino

Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**CWI Present:**	☑ Yes	☐ No	
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A
				Approved WPS:	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At OBG 14E-PP127.2-E5 vent hole infill plate to top deck plate inside, ABF welder Erick Sparks was observed continuing to perform 4G Shielded Metal Arc Welding (SMAW) welding fill pass to cover pass on the infill plate to top deck plate butt joint. The welder was noted using 1/8” diameter E7018H4R implementing Welding Procedure Specification (WPS) ABF-WPS-D15-1110A Rev.1 for the Seismic Performance Critical Member (SPCM) butt joint. During welding, ABF QC Salvador Merino was noted monitoring the welder’s welding parameters with measured working current of 130 amperes on the 1/8” diameter E7018H4R electrode. The welder was noted preheating the plates to more than 150°F using propylene gas torch prior welding. During the shift, cover pass welding was completed on the bottom side of the butt joint.

At the request of Quality Control Field Supervisor, Bonifacio Daquinag, QA has randomly verified the QC VT/MT of the Complete Joint Penetration (CJP) welding of six (6) vent hole infill plate and four (4) lifting lug infill plate to top deck plate butt joints. The QA verification was performed to verify that the welding and the VT/MT inspection performed by the QC inspector meet the requirements of the contract documents. At the conclusion of the QA verification it appeared that the weld and the QC inspection complied with the contract documents.

1. OBG 14W-PP126.2-W3.2 outside - QA VTMT verified

2. OBG 14W-PP126.7-W3.2 outside - QA VTMT verified
3. OBG 14W-PP126.2-W3.7 outside - QA VTMT verified
4. OBG 14W-PP125.7-W3.7 outside - QA VTMT verified
5. OBG 14W-PP126.2-W2.4 outside - QA VTMT verified
6. OBG 14W-PP125.2-W4.2 outside - QA VTMT verified
7. OBG 14E-PP125-E4-#1 lifting lug hole infill plate to top deck plate outside - QA VTMT verified
8. OBG 14E-PP125-E4-#2 lifting lug hole infill plate to top deck plate outside - QA VTMT verified
9. OBG 14E-PP125-E4-#3 lifting lug hole infill plate to top deck plate outside - QA VTMT verified
10. OBG 14E-PP125-E4-#4 lifting lug hole infill plate to top deck plate outside - QA VTMT verified

At OBG 14E-PP125-E4-#1 to 4 lifting lug hole infill plate to top deck plate outside, the lifting lug holes adjacent base metal (approximately 6” to 8”) were tested using Magnetic Particle Testing (MT) in addition to the same test that was performed to the same holes for the purpose of information only in view of the found linear indication on one (1) of the lifting lug holes.

Summary of Conversations:

No significant conversation ocurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo,Joselito	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer